



## Technical Data Sheet

### POLYMARK A254 Two-Component Epoxy Adhesive/ Sealant

#### Product Description:

Polymark A254 is a two-component, fast curing epoxy adhesive/sealant. Polymark A254 produces a strong bond adhering to a wide variety of materials making it an excellent choice for bonding and sealing various metals, plastics and other common assembly materials.

Polymark A254 has a medium viscosity to facilitate various assembly and sealing applications. The system has a convenient one to one mixing ratio. The cure of A254 can be accelerated with the application of moderate heat.

Due to the rapid, exothermic reaction rate of P254, a single, monolithic casting is not recommended. It is best to limit the thickness to 0.5 inch or less.

#### Typical Product Handling Properties:

<u>CHARACTERISTIC</u>	<u>VALUE</u>
<b>Resin:</b>	
Color	Amber
Density (gram/cc)	1.16
Viscosity @25°C	12,000 cps
<b>Hardener:</b>	
Color	Black
Density (gram/cc)	0.98
Viscosity @25°C	10,000 cps
<b>Mixing Ratio (Resin to Hdnr)</b>	
By weight	100:84
By volume	1:1
<b>Working Life:</b>	
<b>Cure Time (@25°C):</b>	
1/2 inch section	1 hour
1/8 inch section	2 hours

#### Typical Cured Physical Properties

<u>CHARACTERISTIC</u>	<u>VALUE</u>
Color	Black
Specific Gravity (g/cc)	1.07
Cured Hardness (Shore D)	70
Moisture Absorption (24hrs)	0.2%
Dielectric Constant	4.4
Tensile Strength (psi)	3,500
Tensile Elongation	20%

The above tests are derived from ASTM procedures. Contact Polymark for further information.

The above cured physical properties were developed using a cure schedule of 24 hours at 25°C. The choice of the user's cure schedule will depend on the application and the user must determine suitability.

#### **Proportioning and Mixing:**

Polymark epoxies can be proportioned by weight or volume. These ratios are stoichiometrically calculated and should be closely followed. Automated meter-mix dispensing equipment may be used for high volume production. (A list of dispensing equipment manufacturers is available from Polymark.)

#### **Shelf Life:**

Polymark A254 has a shelf life of 1 year when stored in sealed containers at 25°C.

All A254 containers are labeled with the date of manufacture. Customers should use this date to insure inventory is used on a first in, first out basis.

#### **Handling Safeguards:**

Closely follow instructions on the labels of Polymark materials containing information on the hazards associated with each particular product. Most epoxy resin systems are skin and eye irritants and more serious health hazards may exist. Consult the Material Safety Data Sheet for further information prior to use.

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**Important Notice to Users:** Typical properties are shown in this technical bulletin and should not be used or taken as specifications. Contact Polymark prior to establishing specifications. The information given for product description, handling properties and cured physical properties are offered solely to assist the purchaser's own testing. Polymark, its sales agents and distributors make NO WARRANTY OF MERCHANTABILITY OF THE PRODUCT OR THE FITNESS OF THE PRODUCT FOR ANY PARTICULAR PURPOSE. This product and all information supplied in connection with it is used at the purchaser's own risk, conditions of use being beyond Polymark's knowledge or control. The purchaser assumes all risk of use or handling of the product, whether in accordance with directions or not.